

# Work Order ID 101993

\*101993\*

Page 1

May-22-13 10:58:50 AM

Item ID: D4769-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate

Start Date: 5/22/13 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: cl Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4769

A

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per dwg

prog rev: A

dwg rev: A

2-Deburr if required

0.00

2

0

Jm13-5-22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

2

0

Jm13-5-22

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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				2			
*120*		0.00							
QC	Memo								
Quality Control									
130		0.00							
*130*		0.00				2			
Small Fab	Memo								
Small Fab	Form as per dwg D4769								
140	QC5- Inspect part completeness to step on W/O	0.00				2			
*140*		0.00							
QC	Memo								
Quality Control									

SB  
13/05/27

47  
13 S 23

49  
27  
13 S 27

Work Order ID 101993

\*101993\*

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May-22-13 10:58:50 AM

Item ID: D4769-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate

Start Date: 5/22/13 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>W/5001</i>	0.00							
<b>*150*</b>						<i>2</i>	<i>62</i>	<i>13-5-28</i>	
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

*13/5/29*  
*ME*  
*13-5-28*

# Picklist Print

May-22-13 10:58:50 AM

Page 1

Work Order ID: 101993

Parent Item: D4769-1

Parent Item Name: Wearplate

Start Date: 5/22/13

Required Date: 5/24/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

sf

351.1699

22315789  
2.5

JmB-5-22

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT019

256.8

117188

5

117766

5

120604

5

122325

3

123155

3

124572

153.8

125552

82

125552

MAT020

94.369894

120243

2

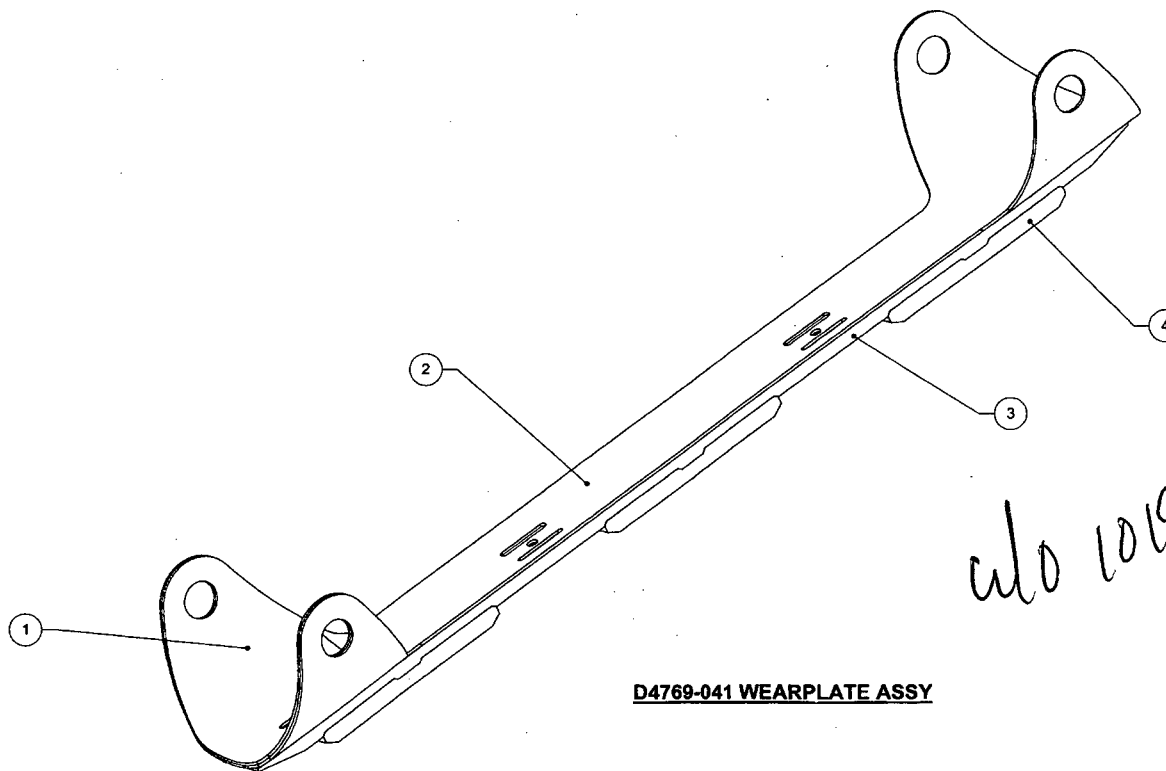
121626

1.529894

124029

90.84

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4769-041	WEARPLATE ASSY
1	1	D4682-9	WEARPLATE SHIM
2	1	D4769-1	WEARPLATE
3	2	D4770-1	BAR
4	A/R	2059B	HARDCOAT WELD



**D4769-041 WEARPLATE ASSY**

*cto 10/19/93*

**RELEASED**  
2013-03-25

A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	<b>DART AEROSPACE USA, INC.</b> KENT, WA DRAWING NO. <b>D4769</b> REV. A SHEET 1 OF 4 TITLE <b>WEARPLATE ASSY</b> NTS <small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	AP		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	13.02.13		

D4682-9 WEARPLATE SHIM

TYP

10

11 9

11 9

**SECTION B-B** C4-2  
SCALE 1X

2059B HARDCOAT

C7-2 B

D4769-1 WEARPLATE

A B7-2

D4770-1 BAR

**DETAIL A** C3-2 [B]  
6 PL  
SCALE 2X

**D4769-041 WEARPLATE ASSY**

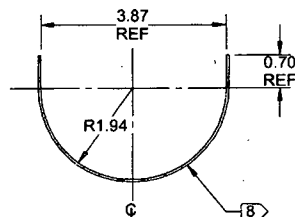
RELEASED  
2013-03-25

**NOTES:**

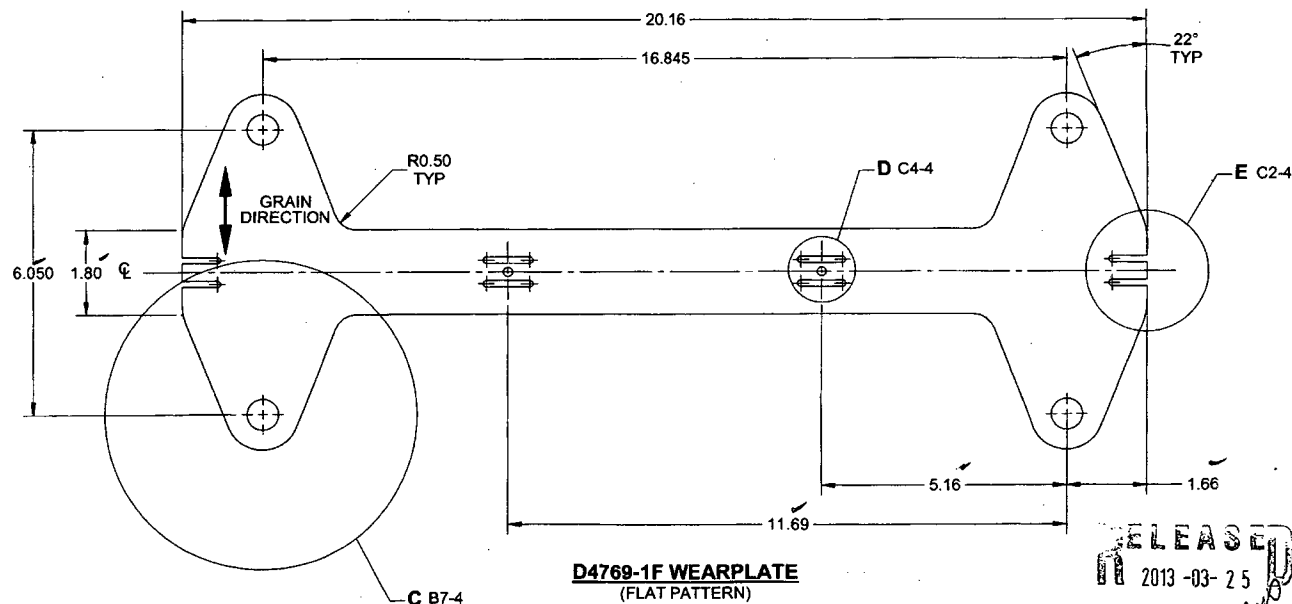
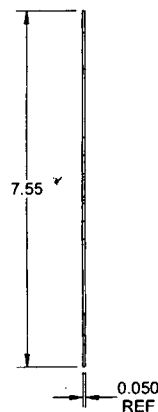
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4769-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 4.79 lbs
- 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD, 0.32 THICK X 0.50 WIDE, FLUSH WITH D4770-1 BAR ON LATERAL SURFACES, 6 PL
- 9) TRANSFER DRILL  $\varnothing 0.188$  HOLE FROM D4769-1 WEARPLATE TO D4770-1 BAR
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH LAYER OF PLUS ONE ROCKGUARD 4714, 0.020 - 0.040 THICK
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO  $\varnothing 0.188$  AFTER APPLYING PLUS ONE ROCKGUARD

DESIGN	DB
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APPROVED	[Signature]
DE APPR.	[Signature]
DATE	13.02.13

<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWING NO. <b>D4769</b>	REV. A SHEET 2 OF 4
TITLE <b>WEARPLATE ASSY</b>	SCALE NTS
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**D4769-1 WEARPLATE**  
(MAKE FROM D4769-1F)



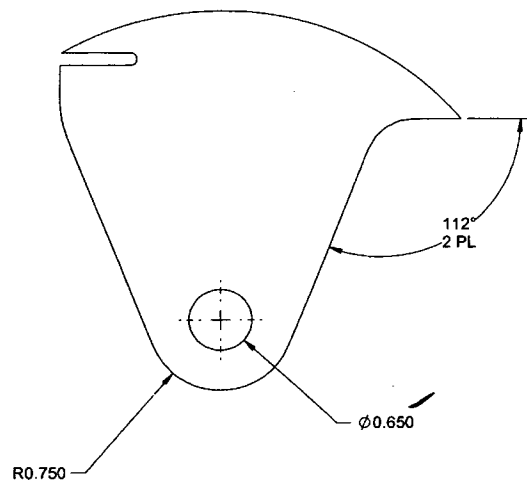
**D4769-1F WEARPLATE**  
(FLAT PATTERN)

**NOTES:**

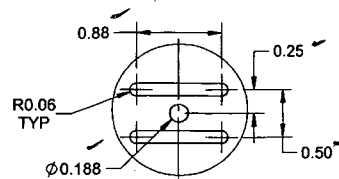
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.85 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4769-1 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

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MFG. APPR.		<b>D4769</b>	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSY</b>	NTS
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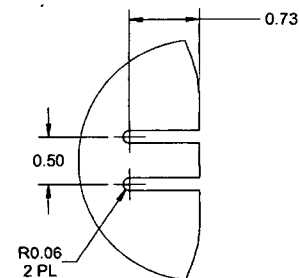
RELEASED  
2013-03-25



**DETAIL C** B5-3  
4 PL  
SCALE 2X



**DETAIL D** B3-3  
2 PL  
SCALE 2X



**DETAIL E** B1-3  
2 PL  
SCALE 2X

RELEASED  
2013-03-25  
MP

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MFG. APPR.	<i>[Signature]</i>	TITLE <b>WEARPLATE ASSY</b>	SHEET 4 OF 4
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	101993
<b>Description:</b> Wearplate		<b>Part Number:</b>	D4769-1
<b>Inspection Dwg:</b> D4769 Rev: A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.188"	+0.005 -0.001	0.189"	-		V	Item 01
Ø 0.650"	+0.008 -0.001	0.651"	-		V	
0.88"	+/- 0.030"	0.882"	-		V	
0.50"	+/- 0.030"	0.507"	-		V	
0.25"	+/- 0.030"	0.253"	-		V	
0.73"	+/- 0.030"	0.73"	-		V	
1.80"	+/- 0.030"	1.813"	-		V	
6.050"	+/- 0.010"	6.054"	-		V	
7.55"	+/- 0.030"	7.549"	-		V	
1.66"	+/- 0.030"	1.66"	-		V	
5.16"	+/- 0.030"	5.155"	-		V	
11.69"	+/- 0.030"	11.677"	-		V	Product
16.845"	+/- 0.010"	16.845"	-		T	Item 06
20.16"	+/- 0.030"	20.16"	-		T	
0.090"	+/- 0.010"	0.096"	-		V	

<b>Measured by:</b> Jm	<b>Audited by:</b> <sup>DA</sup> 27	<b>Preliminary Approval:</b>
<b>Date:</b> 13-5-22	<b>Date:</b> 13.5.23	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15